

Work Order ID 67004

Thursday, March 03, 2011 10:46:58 AM

Page 1

Item ID: D3911-5

Accept

Revision ID:

Item Name: Basket Stud Plate

Start Date: 3/3/2011 Start Qty: 6.00

Required Date: 3/7/2011 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date: 11-03-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3911

D

0.00

0.00

0.00

0.00

100



Waterjet

FLOW CNC Waterjet

304 . 105

Memo

Cut as per dwg D3911

Prog Rev: D

Dwg Rev: D

Deburr as required

1B11-3-7

⑩

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

1B11-3-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67004

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Page 2

Item ID: D3911-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Stud Plate

Start Date: 3/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8/10/07

(40)

Quality Control

inspects 6 Rev D Dwg.

130

Identify as per dwg & Stock Location: 91

0.00



Packaging

Memo

0.00

11/3/7 SP

10x counts

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/3/7 DJ

Quality Control

CL 11/03/07

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 10:47:05 AM

Page 1

Work Order ID: 67004



Parent Item: D3911-5



Parent Item Name: Basket Stud Plate

Start Date: 3/3/2011



Required Date: 3/7/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC
AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	38.0000	0.0299	0.188842	.4		
304/316 0.125 Sheet													

H311-3-7

Location

Loc Qty

Loc Code

MAT

38

116623

38

116623

10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
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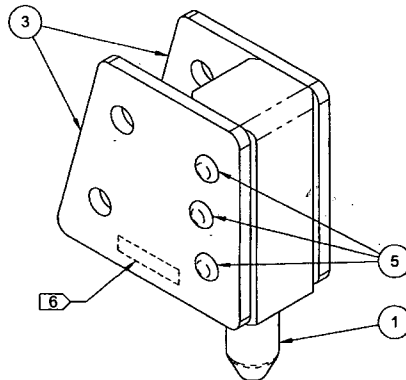
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

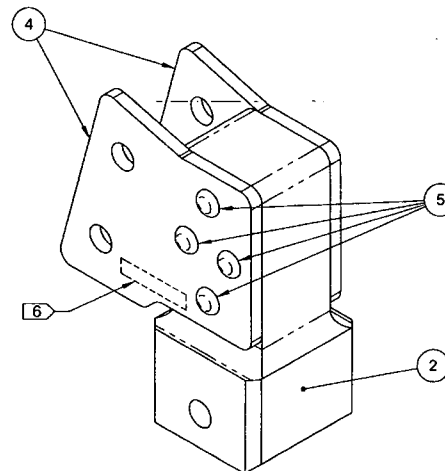
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET



D3911-041 BASKET INSTL STUD ASSY (LOWER)



D3911-043 AFT EYEBOLT RECEIVER ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67004
P111-03-3

RELEASED
2010-08-06

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs

D	0.825 +0.000/-0.010 WAS 0.65 (B1-2).	MB	10.06.22
C	BOM: QTY (2): D4087-1 & MS21209-C610 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. D
MFG. APPR.	JPH	D3911	SHEET 1 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	AFT HARDPOINT, BASKET NTS	
DATE	10.06.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

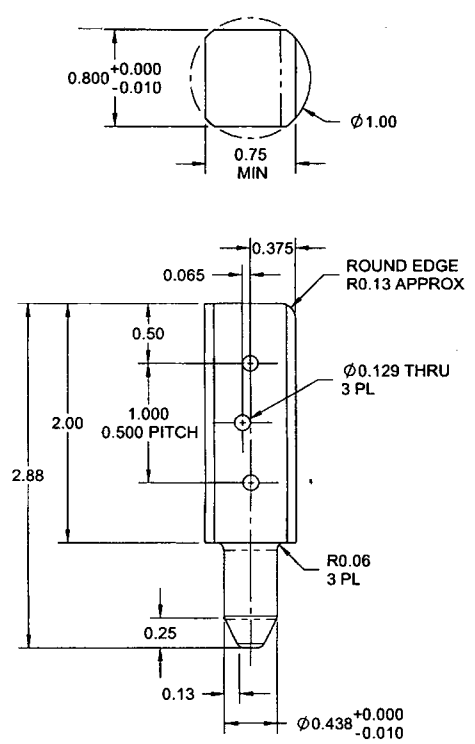
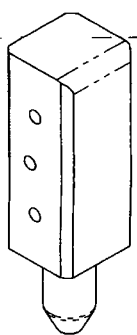
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D

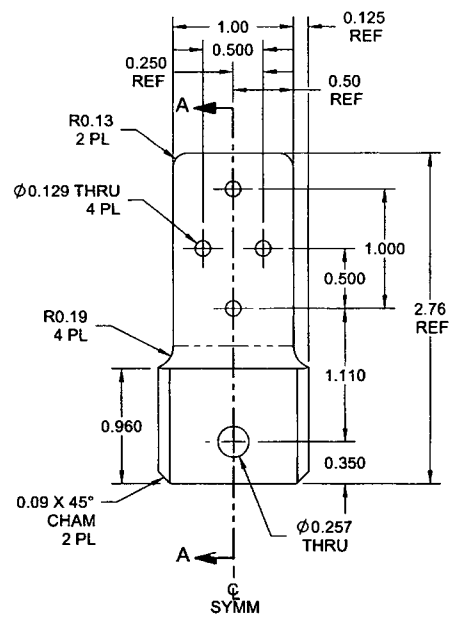
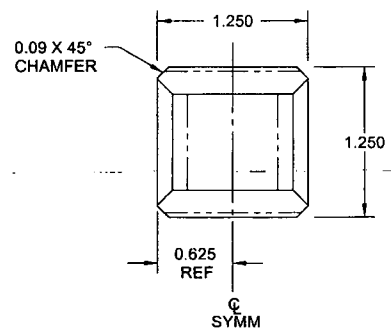
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B

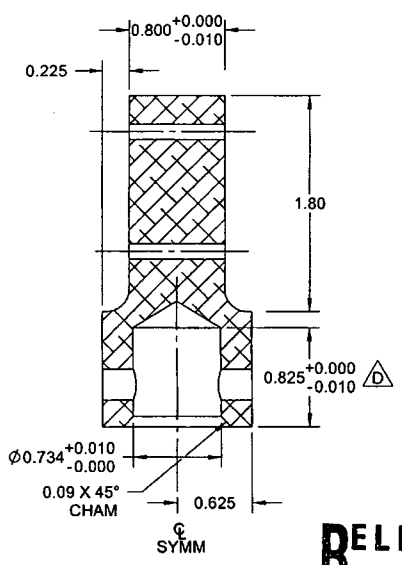
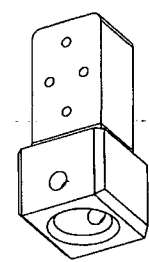
A



D3911-1 BASKET INSTL STUD (LOWER)



D3911-3 AFT EYEBOLT RECEIVER



SECTION A-A

RELEASED
2010-08-04
JMD

NOTES:

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
-3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs
-3: 0.71 lbs

WLG 7004

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3911	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR: --		AFT HARDPOINT, BASKET	
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8 7 6 5 4 3 2 1

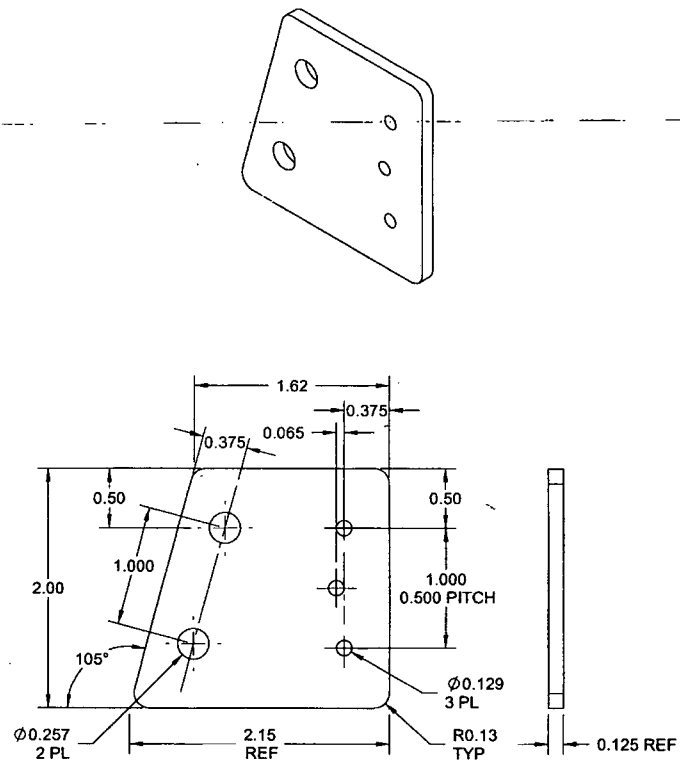
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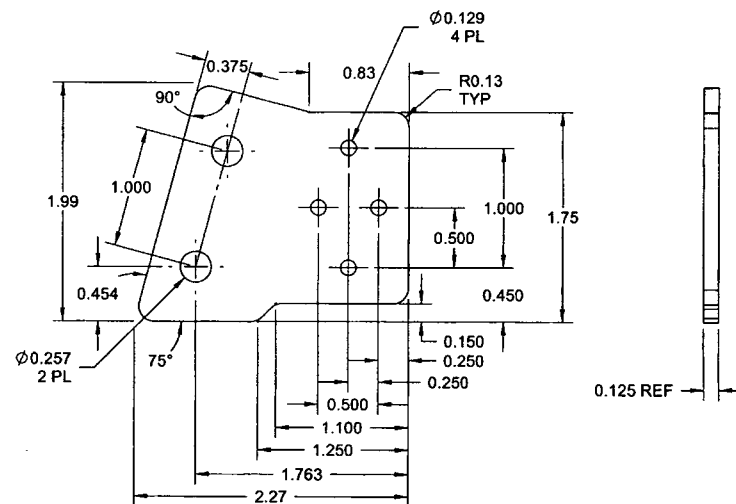
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NOTE: Date & initial all entries



D3911-5 BASKET STUD PLATE



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

NOTES:

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT--5: 0.13 lbs
--7: 0.13 lbs

WLO 67009

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3911	REV. D SHEET 3 OF 3
MFG. APPR.		TITLE AFT HARDPOINT, BASKET	SCALE NTS
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DE APPR.			
DATE	10.06.22		

RELEASED
2010-09-06
M

W/O:		WORK ORDER CHANGES					
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